

76983

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

12

12

Run Start *NR1*

Date:

Stop ***NR2***

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3660	Rev B								
100		0.00							
100	BAND SAW					12			
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blank 7.300 " long		SA	12/2/14					
110		0.00							
110	DOOSAN LATHE								
Doosan	Memo	0.00							
Doosan Lathe	1-Turn as per folio FA 708 & DWG D3660, FOLIO REV: <u>B</u> DWG REV: <u>B</u> 2-Deburr as required		SA	12/2/15		12			
120		0.00							
120	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control			SA	12/2/15		12			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76983

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November-24-11 2:41:52 PM

Item ID: D3660-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: CUFF
 Start Date: 24/11/2011 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 08/12/2011 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		<i>OK 12/02/15</i>		<i>12</i>			
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							<i>12x4 m / 12/02/16</i>
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>12</i>			<i>BR 12.2.16</i>

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Page 3

November-24-11 2:41:52 PM

Item ID: D3660-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: CUFF
 Start Date: 24/11/2011 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 08/12/2011 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <i>402</i>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

MCS 12/02/17

p12-0216
(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 76983

76983

Parent Item: D3660-1

D3660-1

Parent Item Name: CUFF

Start Date: 24/11/2011

Required Date: 08/12/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP rev A new issue 07.09.19 EC verified by:JLM
IPP Rev:B 08-04-07 chg to revB DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6008-180		Manufactured	No			100	Each	16.0000	0.056	0.707368			
D6008-180									**			12/2/14	
Crosstube Extrusion													

Location

Loc Qty

Loc Code

LG

16

46779

1

59249

15

* Ledhauer scrap from x-tube extrusion B46779 ⇒ 8 Lt

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

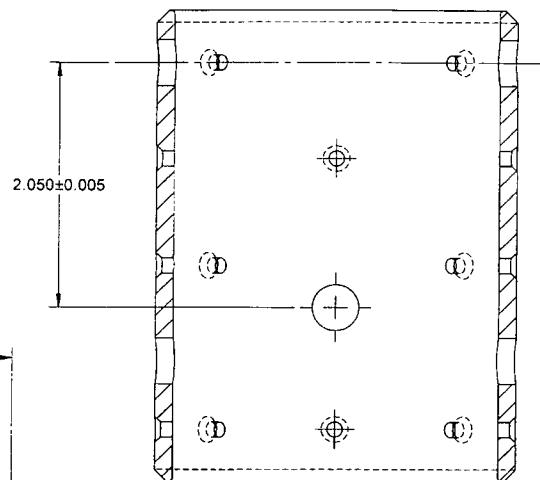
W/O:		WORK ORDER CHANGES					
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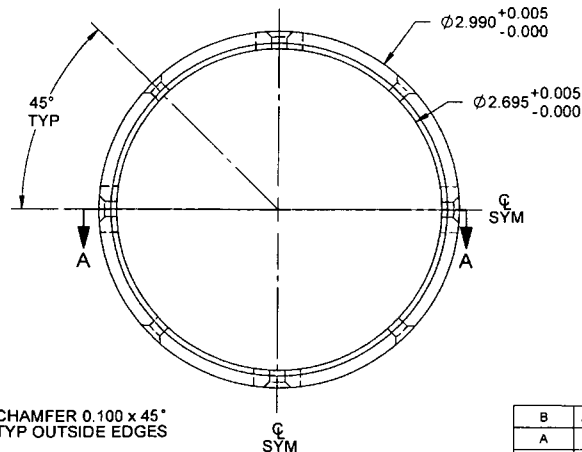
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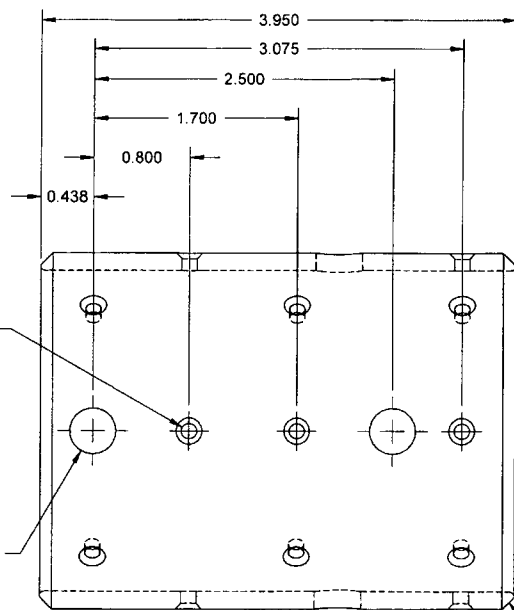
R0.032 TYP
INSIDE EDGES

SECTION A-A



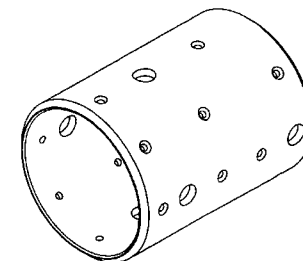
CHAMFER 0.100 x 45°
TYP OUTSIDE EDGES

D3660-1 CUFF



DRILL #30 (Ø0.128 REF)
C/SINK Ø0.230X100°
TYP 22 PLACES

Ø0.386 +0.005/-0.000
HOLE TO BE ALIGNED
WITHIN ±0.001 OF HOLE
ON OTHER SIDE OF CUFF,
TYP 6 PLACES



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REVISION TO
DRAWING
UNCONTROLLED COPY
SUBMITTAL
NOTICE
NO. 76983 M.C.J.
11/11/24

NOTES:

- 1) MATERIAL: 7075-T6/T6511 SEAMLESS TUBE (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11)
(CAN MAKE FROM D6006, D6008, OR D6009)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.50 lbs

B	ADD Ø0.128 & Ø0.386 HOLES (B8)	CP	08.03.03
A	NEW ISSUE	CP	07.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.03.03		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3660	REV. B
TITLE CUFF	SCALE NTS
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